AMENDMENT(S) TO THE SPECIFICATION

Please delete the heading at page 1, line 2.

Please replace the paragraph beginning at page 1, line 3, in the originally filed application, which is after the paragraph added beginning at page 1, line 3, of the specification, by the Preliminary Amendment filed with the originally filed application, with the following rewritten paragraph:

BACKGROUND OF THE INVENTION

Field of the Invention

The invention relates to a tool for the cutting machining of precision bores in workpieces ~~according to the preamble of claim 1~~.

Description of the Related Art

Please replace the paragraph beginning at page 1, line 17, with the following rewritten paragraph:

To achieve this object, a tool is proposed ~~which has the features mentioned in claim 1. It is distinguished~~ in ~~that~~ which the first machining step has at least three support regions which are arranged at a distance from one another in the circumferential direction and which are designed and arranged such that they are supported on the wall of a precision bore during the machining of the latter. Since the tool bears directly against the bore wall and not against any guide devices, during the machining of a workpiece it does not require any additional devices which hold the tool in a specific position with respect to said workpiece. The use of the tool is thereby simplified substantially.

~~Further embodiments may be gathered from the subclaims.~~

Please insert the following heading at page 2, before line 6:

BRIEF DESCRIPTION OF THE DRAWINGS

Please insert the following heading at page 2, before line 22:

DESCRIPTION OF THE PREFERRED EMBODIMENT(S)

Please replace the paragraph beginning at page 7, line 5, with the following rewritten paragraph:

Figure 2 shows part of the tool 1, to be precise the third machining step 15. The machining step 15, in the illustration according to figure 2, is rotated about the center axis 39 in such a way that the honing strip 41 is arranged on top. The illustration according to figure 2 is enlarged, as compared with that in figure 1. Identical parts are given the same reference numerals, and therefore, to that extent, reference is made to the preceding description. Figure 2 serves particularly for a further explanation of the exchangeable honing strip 41. The latter is inserted into a groove 65 which is introduced into the basic body 67 of the third machining step 15. Said honing strip is held by the two clamping claws 61 and 63, the clamping lips of which lie on a side face 69 of the honing strip 41 and firmly clamp the latter in the basic body [[47]] 67. This is discussed in more detail below.

Please replace the paragraph beginning at page 9, line 14, with the following rewritten paragraph:

Figure 2 also shows the conical depression 81 which is introduced into the end face 21 of the third machining step 15 and which was explained with reference to figure 1 and serves for receiving the conical shank 23 of the second machining step [[19]] 9.

Please replace the paragraph beginning at page 10, line 15, with the following rewritten paragraph:

The groove 65 is delimited by two side flanks 85, 87 standing essentially perpendicularly on the base 83, the side flank 85 which is on the right in figure 3 serving as bearing contact for the honing strip 41, and the side flank 87 which is on the left in figure 3 being pierced, so that the clamping claws act on the side face 69 of the honing strip 41 and can press the latter against the side face 85 and the base 83. Figure [[1]] 3 illustrates by way of example the clamping claw 61 which retains the honing strip 41 by means of a clamping lip 89. Said honing strip is provided, on the side face 69 facing the clamping claw 61, with a clamping groove 91 which has a clamping face 93.

Please replace the paragraph beginning at page 14, line 25, with the following rewritten paragraph:

This aim is achieved in that the tool 1 is of modular construction and has two machining steps 3 and [[5]] 9 having in each case at least one knife plate 5 and 11 possessing geometrically defined cutting edges 7, 13. These serve for the cutting machining of the surface of the precision bore and for generating the desired bore geometry. When the tool 1 is introduced into a bore to be machined, first, the foremost first machining step 3 comes into engagement with the bore wall, then followed by the second machining step 9. Since the first machining step 3 and the second machining step 9 are aligned highly accurately with one another and with the third machining step 15, the precision bore can be premachined and intermediately machined highly accurately with the aid of the first two machining steps. The dimensional deviation of the machined precision bore with respect to the desired dimension is approximately 1/100 mm to 2/100 mm after the intermediate machining.

Please replace the paragraph beginning at page 16, line 22, with the following rewritten paragraph:

Owing to the low oversize remaining for finish machining, the third machining step 15 has to be moved to and fro in the axial direction only ~~once~~ one to three times in the precision bore to be machined. This shortens the machining time for the precision bore in a lasting manner. According to the statement made above, the minimization of the strokes is possible because the third machining step 15 is arranged in highly accurate alignment with the other machining steps, and only a very low cutting depth is required. A decisive advantage of the tool described here is therefore that the latter can be used on normal machine tools, because the cardanic suspension conventional for honing tools may be dispensed with and there is no need for any additional supporting and/or guide devices.

Please replace the paragraph beginning at page 20, line 8, with the following rewritten paragraph:

The ~~second~~ first machining step 9' has a number of knife plates, of which the knife plates 11, 11' and 11" are identified here by reference numerals. The first machining step 9' can be coupled to the second machining step 15' via a precision interface which, here too, is designed as a short-taper

connection.

Please replace the paragraph beginning at page 25, line 2, with the following rewritten paragraph:

Figure 7 shows a knife plate 11 in a perspective view obliquely from the front. Regardless of the actual shape of the knife plate 11, the latter always has a main cutting edge 113 descending in the direction of ~~the direction of~~ advance indicated by an arrow 111. Descending means here that, as seen in the direction of advance, the main cutting edge approaches the axis of rotation, not illustrated here, of the machining step. The main cutting edge 113 merges via a vertex 115 into the secondary cutting edge 117. The latter is inclined in the opposite direction and, as seen in the direction of advance, ascends in the direction of the vertex 115. It is thus shown that the main cutting edge 113 and the secondary cutting edge 117 are inclined in opposite directions from the vertex 115.

Please replace the paragraph beginning at page 26, line 18, with the following rewritten paragraph:

The circularly ground chamfer is produced in the region of the first flank 123 of the secondary cutting edge [[27]] 117. This region is then designed to be curved such that the chip face 119 has adjoining it a curved region, the radius of curvature of which is measured from the axis of rotation of the tool 1, 1'. The radius of curvature preferably corresponds to that of the precision bore to be machined.